

Date: Monday, 22/09/2008 1:03:40 PM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 42176	
Estimate Number : 11218	
P.O. Number :	Part Number : D34173
This Issue : 22/09/2008 S.O. No. :	Drawing Number : D3417 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 39732	Material :
Written By :	Due Date : 29/09/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JLD 08.9.22</u>	
Comment : Est Rev:A 05.10.19 New issue KJ/EC	
Est Rev:B 05.10.19 added haas op. EC	
Est Rev:C As per Rev D 08-07-09 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELNR12500 <del>1.250</del>	DELIN ROUND BAR 1.25"
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Comment: Qty.: 0.0311 f(s)/Unit Total: 1.5540 f(s)

Material: Delrin Round Bar ~~Ø1.250~~

(M-DELIN-R1.250)

Batch: ~~142208-0001~~

Identify for D3417-3

\* M109020 → 1.750 Delrin

~~142208-0001~~

SD 08/11/06

2.0	<del>HARDINGE</del>	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA594 Rev: N/A & Dwg D3417 Rev: D

2-Deburr

SD 08/11/06

(56)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 08/11/06

(56)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

-Machine as per folio FA594 rev. \_\_\_\_\_ &amp; dwg D3417 rev. \_\_\_\_\_

N/A 44

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
2.09.30	2.	New on DOOSAN Lathe	<i>[Signature]</i>	2.09.30				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/09/2008 1:03:40 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 42176

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



N/A

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

RG 08/11/07

(56)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

RG 08/11/07

(56)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

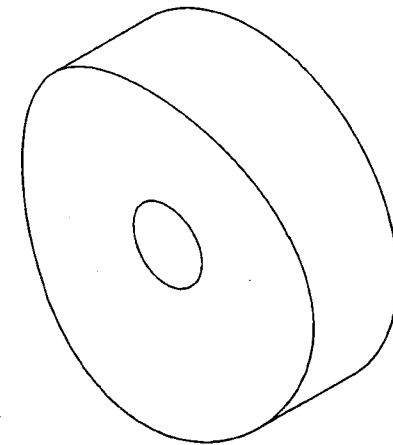
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

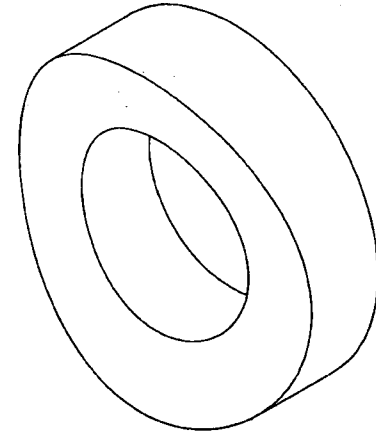
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

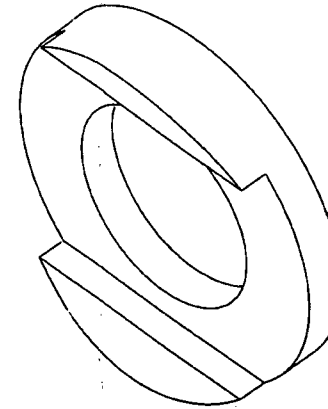




**D3417-1 WASHER**



**D3417-3 WASHER**



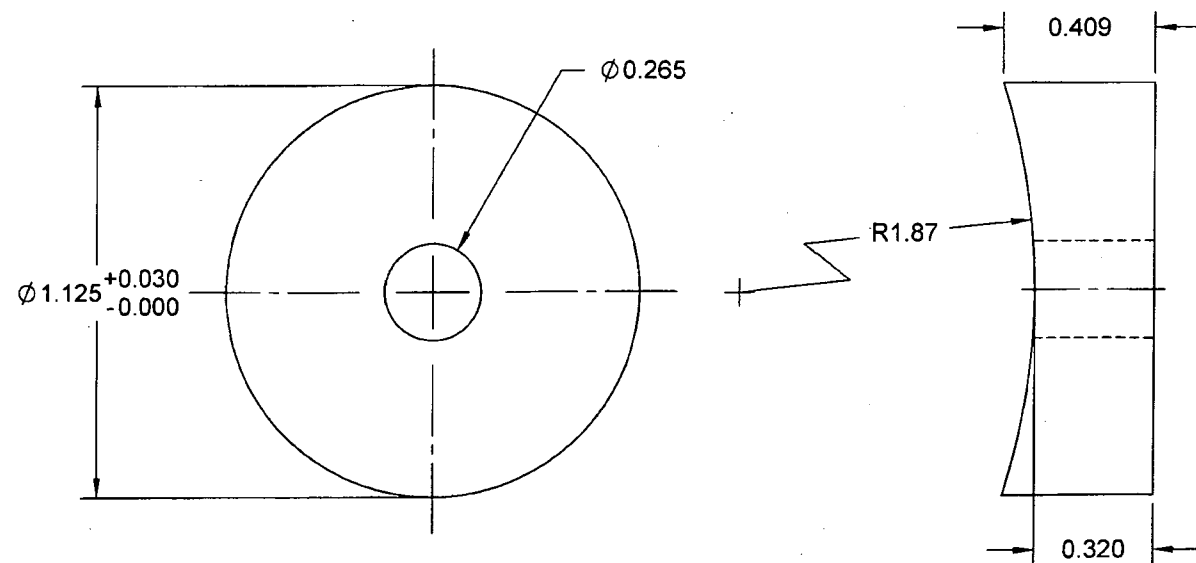
**D3417-5 WASHER**



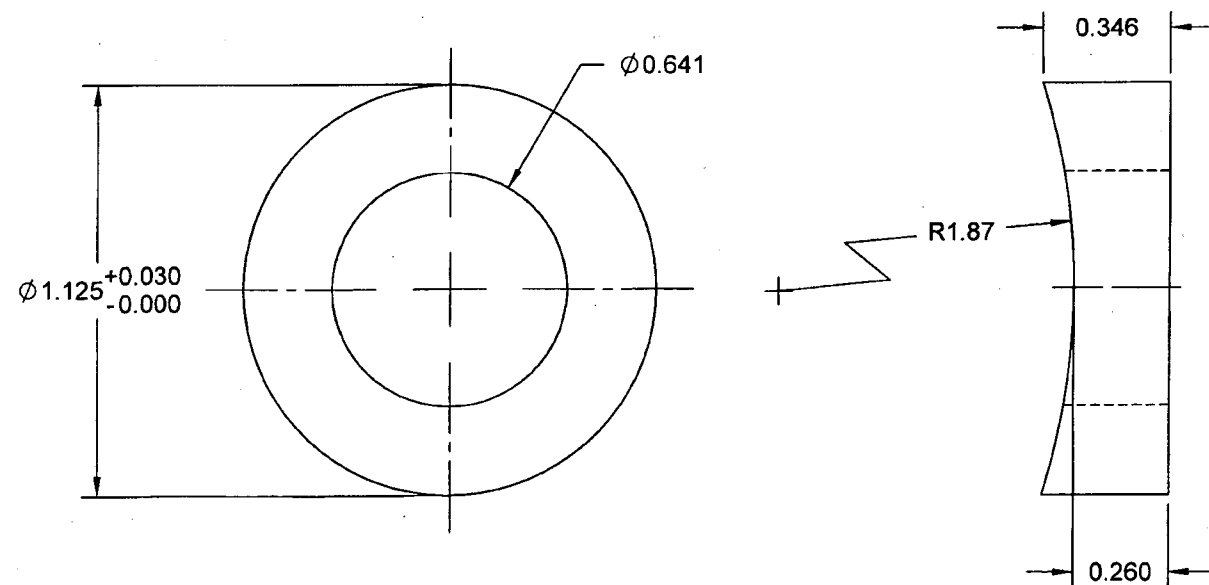
- NOTES:**
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELRIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELRIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELRIN-S
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D3417-1, 0.02 lbs  
D3417-3, 0.01 lbs  
D3417-5, 0.01 lbs

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06-06-01/17

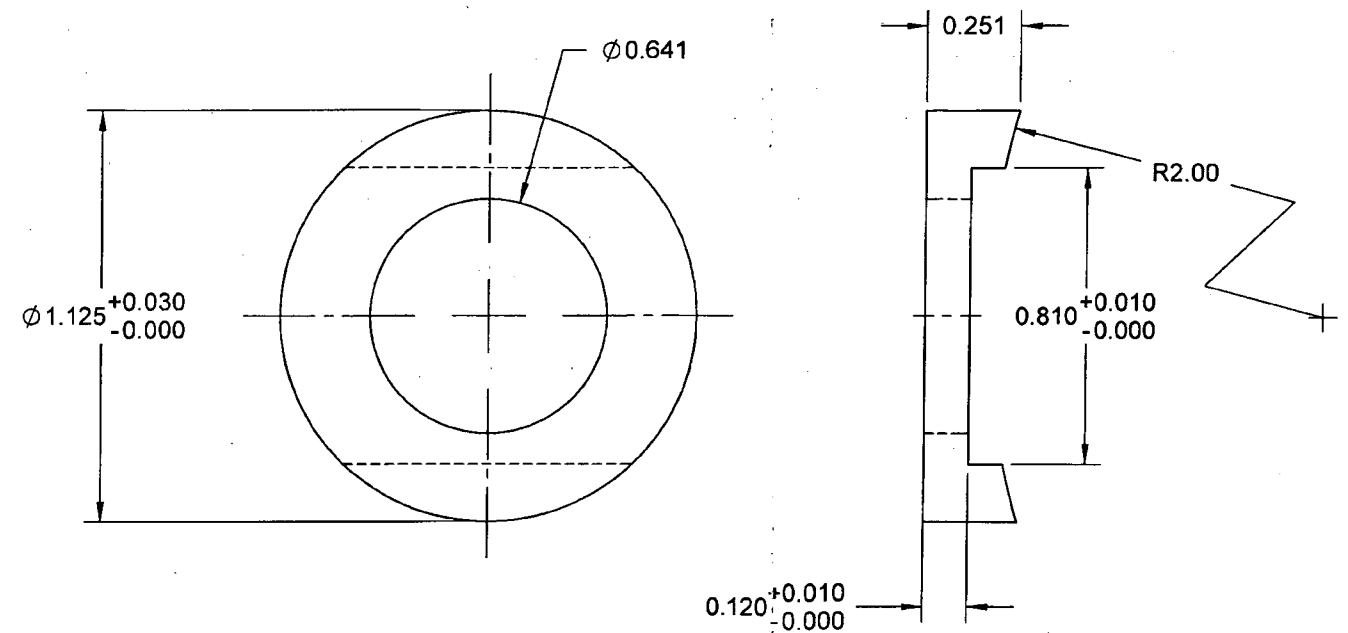
REV.	DESCRIPTION	BY	DATE
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	1/24	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. D
MFG. APPR.	1/24	D3417	SHEET 1 OF 2
APPROVED	1/24	TITLE	SCALE
DE APPR.	1/24	WASHER	NTS
DATE	08.07.08	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



**D3417-1 WASHER**



**D3417-3 WASHER**



**D3417-5 WASHER**

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WITHOUT NOTICE  
WORK ORDER  
NO. 4217

**RELEASED**  
08.08.01

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3417	SHEET 2 OF 2
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